

Date: Monday, 07/04/2008 11:47:08 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT CROSSTUBE		
Job Number	: 38427			Part Number	: D2890		
Estimate Number	: 10377			Drawing Number	: D2890 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/04/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 10/05/2008 Qty: 1 Um: Each		
Previous Run	: 38426						
Written By	:						
Checked & Approved By	: <u>TD 08.4.0</u>						
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty	Part #	Description
	1	D6008-180	Crosstube extrusion
			<u>B34688</u> EL 8-4-18
2.0	BENDING	BENDING MACHINE - SKIDTUBES	
		Comment: BENDING MACHINE	
		1-Bend D2890 as per Dwg D2890 and Folio FT002	<u>EL 8-4-11</u>
3.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<u>Soloout</u>
4.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	<u>38318</u> <u>used on w/ # 38353</u> <u>38353</u>
		1-Deburr and Polish	<u>38353</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	<u>08/04/4</u>
		Chemical Conversion Coat as per QSI 005 4.1	<u>08/04/4</u>

Date: Monday, 07/04/2008 11:47:08 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38427

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Locality

at user on w/o # 38353 38353  
38353

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

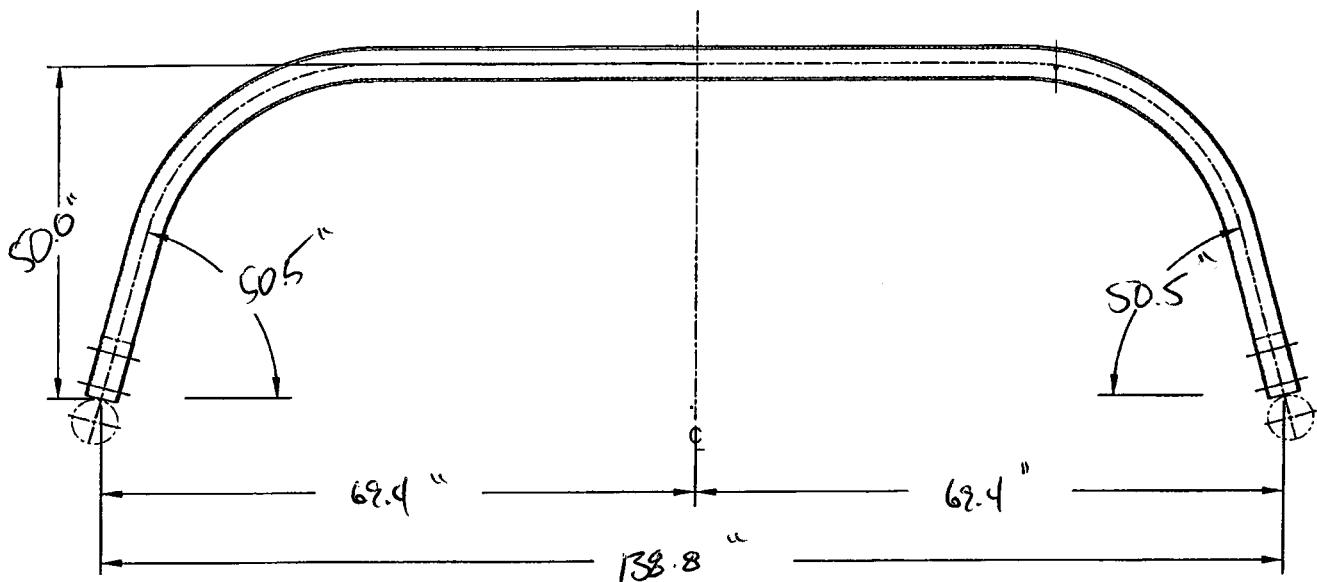


mf 08-04-16

08/04/16 ff

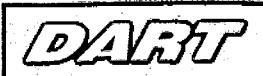
DART AEROSPACE LTD	Work Order:	38421
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments	
* 3 used for 38353 38355 38353	
QC15 Inspection	8/1/11
Date	08/01/11

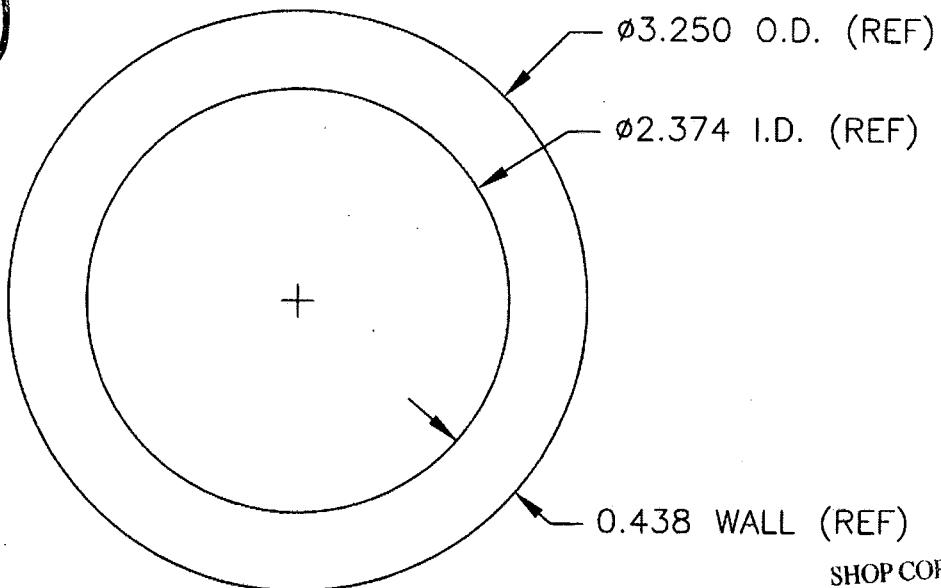
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1
00.11.17		TITLE CROSSTUBE MATERIAL
A	00.11.17	SCALE 1:1
		NEW ISSUE

## SPECIFICATION CONTROL DRAWING

**RELEASED**  
00.11.24



### NOTES

1) D6008-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 180" LONG TUBE: D6008-180

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38427

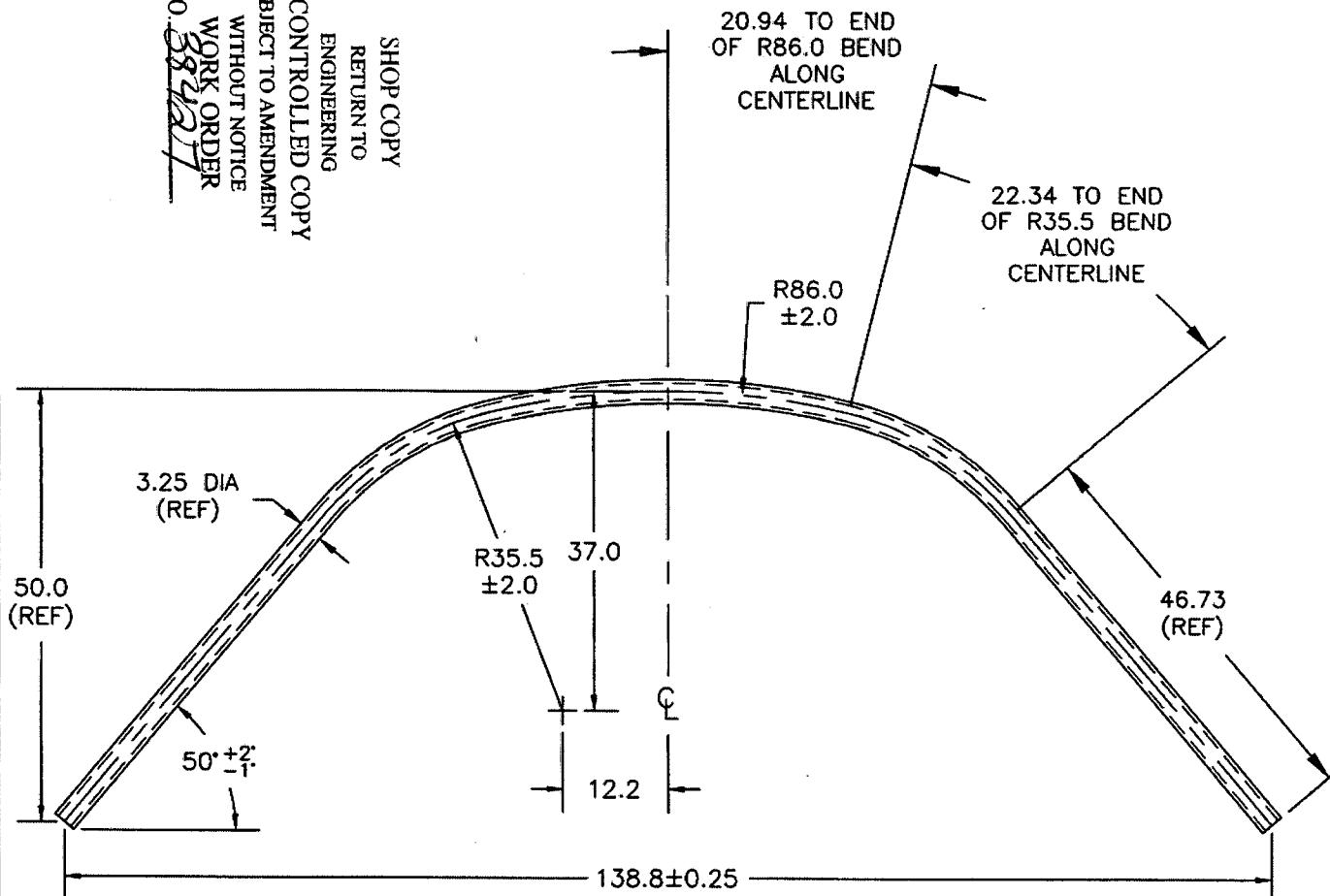
- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.008$  MEAN ( $\pm 0.016$  INCLUDING OVALITY)  
WALL:  $\pm 0.020$  MEAN ( $\pm 0.044$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART****DCOPIA  
GARRETT****RELEASED**  
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	REV. B	
		DRAWING NO.	
		D2890	SHEET 1 OF 1
DATE	TITLE		SCALE
02.10.18	AFT CROSSTUBE		1:20
A	99.05.21		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ( $\varnothing 3.25$  OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.